



Dart Aerospace Ltd.
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Hawkesbury, ON
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order 4186 *May 17*
C10-27
Job Sheet 176252

Part No: C10-27

Job Qty: 1 ea

Part Name: Cage Weldment



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/19/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C10-27 Rev 9 IPP REV A RQ 17.09.05 VERIFIED BY DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/27/18	0.00	0.00	Start Up Large Fab-1		<i>FL</i>
100	Large Fab	1 pcs		4/27/18	0.00	0.00	Large Fab 3		<i>Q</i>
120	QC	1 pcs		4/27/18	0.00	0.00	QC9		<i>10.05.02</i>
140	Powdercoat	1 pcs		4/27/18	0.00	0.00	Powdercoat6		<i>BL 18-5-11</i>
160	QC	1 pcs		4/27/18	0.00	0.00	QC3		<i>SP</i>
180	Packaging	1 pcs		4/27/18	0.00	0.00	Packaging3-1		<i>SP</i>
200	QC21-SA	1 Ea		4/27/18	0.00	0.00	QC21		<i>21 MAY 14 2018</i>

Part Op 100 - US WELD FIXTURE C-10

Descriptions: 140 - START TIME: *8:30* OVEN TEMPERATURE: *320°* FINISH TIME: *9:00*

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
C10-27-1	Lifting Plate	2 Ea (2 ea)	90-Start up Operation	
C10-27-10	Side Loop Wrap Around	2 Ea (2 ea)	90-Start up Operation	<i>5066126</i>
C10-27-2	Cage Reinforcement	2 Ea (2 ea)	90-Start up Operation	
C10-27-3	Front Guard Plate	1 Ea (1 ea)	90-Start up Operation	
C10-27-4-1	Top Ring	2 Ea (2 ea)	90-Start up Operation	<i>506615012</i>
C10-27-8	Bumper Plate	1 Ea (1 ea)	90-Start up Operation	
C10-27-9	Space Bar Wrap Around	2 Ea (2 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	C10-27-1	2	3	0
	C10-27-10	2	0	0
	C10-27-2	2	0	0
	C10-27-3	1	2	0
	C10-27-4-1	2	0	0
	C10-27-8	1	2	0
	C10-27-9	2	0	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

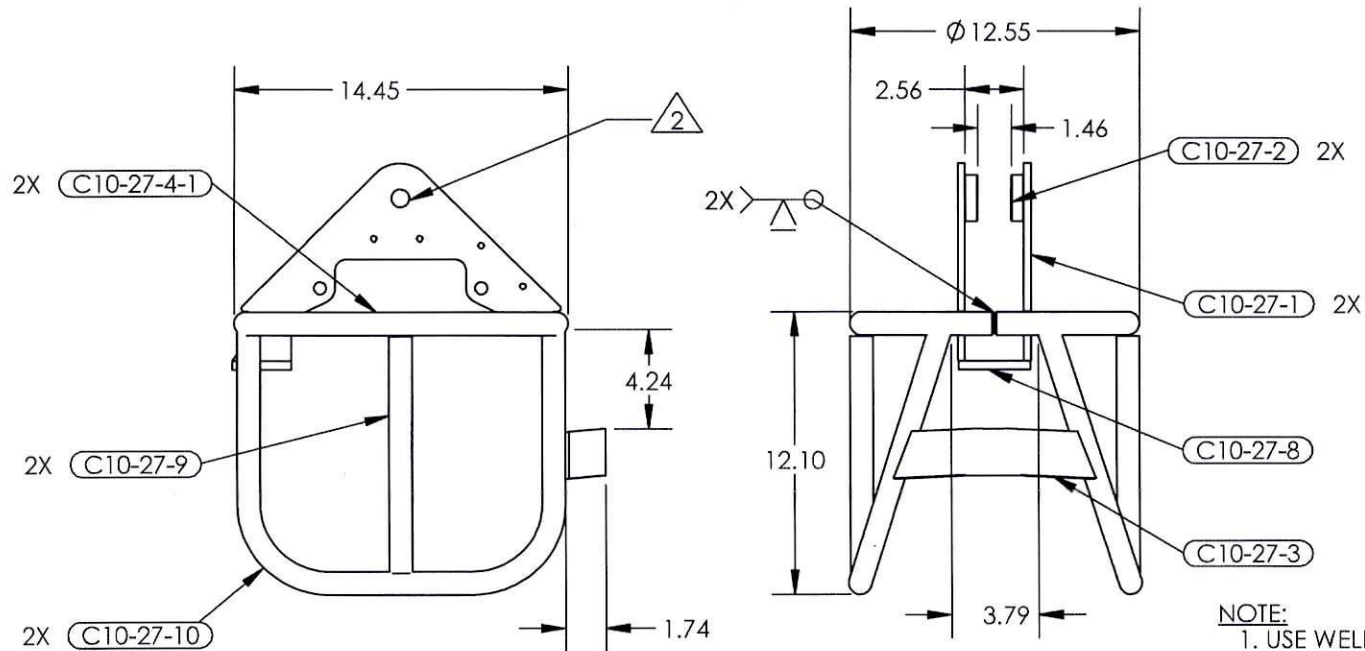
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

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REVISIONS				
REV	ECR	DESCRIPTION	DATE	INITIAL
6		AS DRAWN BY APICAL	1/9/2013	JAG
7		CH'D 1.27 DIMENSION TO 1.75 TO MATCH PARTS	1/9/2013	JAG
8		-9 CH'D LENGTH WAS 10 IS 10-1/8. -10 ADDED COPING 2X R .5 X .25 DEEP.	2/27/2013	BIM
9	16-0169	-9 DELETED FINISH SPEC. WAS RAL 3000 IS NO SPEC, CH'D NOTE 1 ADDED C10. ADDED NOTE 2 CH'D DWG TO SHEET METAL TOLERANCE.	10/13/2016	RJC



NOTE:

1. USE WELD FIXTURE C-10, WELD ALL CONNECTIONS 100%.

2. HOLES MUST ALIGN.

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description
			C10-27-1	2	LIFTING PLATE
			C10-27-2	2	CAGE REINFORCEMENT
			C10-27-3	1	FRONT GUARD PLATE
			C10-27-4-1	2	TOP RING
			C10-27-8	1	BUMPER PLATE
			C10-27-9	2	SPACE BAR WRAP AROUND
			C10-27-10	2	SIDE LOOP WRAP AROUND

DART AEROSPACE	
TITLE CAGE WELDMENT	
DWG NO. C10-27	REV 9
MAT'L HEAT TREAT FINISH POWDER COAT RED SPEC	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX $\pm$.010 FRACTIONS $\pm$ 1/8 .XX $\pm$.03 ANGLES $\pm$ 1° .X $\pm$.1 SURFACES = 125/✓	
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING 3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	
DRAWN BY: APICAL	USED ON MODEL
CHECKED: DUERFELDT	
OPPS APPR: ANDERSON	
QA APPR: LINDSAY	
APPROVED: GILBERT	
SCALE 1:8	DATE 9/26/2006
SHEET 1 OF 1	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION		AGAINST DEPARTMENT/PROCESS							
	Rework	☐	Skid-tube	☐	Cross tube	☐	Water Jet	☐	Engineering	☐
	Scrap	☐	Machining	☐	Small Fab	☐	Prod. Eng. Coord.	☐	Quality	☐
	Use-as-is	☐	Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
	Suspected Unapproved	☐	Large Fab	☐	Composite	☐	Supplier	☐		

Date : _____ Step #: _____

Description Work Order Deviation

DART AEROSPACE
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 Email: sales@dartaero.com
 www.dartaerospace.com
 Part: C10-27
 Job No: 176252
 Serial No/ Batch: S067358
 Revision: 9
 Inspector: _____
 Date: 05/01/18

Root Cause						
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	
Design	☐	Operator	☐	Bending	☐	
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	
Equip/Tooling	☐	Supplier	☐	Cracks	☐	
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	
Material	☐	Use for Testing	☐	Cuffs	☐	
Internal Transport	☐	Poor Information	☐	Crushing	☐	
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	
Past Expiry Date	☐	Manufacturing Process	☐			
Misidentified	☐	Past Due	☐	OTHER :		